

Work Order ID 112194

January-30-14 1:45:23 PM

112194

Page 1

Item ID: D412-742-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 1/30/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-01-31 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG005N/A 

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

HandFinishing

HandFinish

Hand Finishing

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/RSikaflex-241/-291 129457Expiry date: 1/1/11

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 129457Expiry date: 1/1/11

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/RLPS Procyon 1122900

1x 4 90 11/07/2

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Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 1/30/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/30/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	EB	14/07/21		①			
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____	0.00 0.00							1 2 14-08-05
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14/8/6 ② ③ 14-08-05

Picklist Print

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Page 1

Work Order ID: 112194

Parent Item: D412-742-043

Start Date: 1/30/14

Required Date: 1/30/14

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517
 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No				Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		1							
				101639		1							
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				108339		1							
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				108348		1							
AN3C4A Bolt		Purchased	No			110	Each	2,852.0000	24				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		20							
				122814		20							
				ST513		2832							
				125388		1835							
				M127410		497							
				M127832		500							

B114260(1x) JLM 1/10/21

B114513(1x) JLM 1/10/21

B115509(1x) JLM 1/10/21

24 JLM 1/10/21

M128879

x24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 112194

Parent Item: D412-742-043

Start Date: 1/30/14

Required Date: 1/30/14

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 110 Each 481.0000 10 10 1/10/21

Bolt

Location	Loc Qty	Loc Code
FG	10	
122416	10	
ST513	471	
m125709	471	

AN3C7A Purchased No 110 Each 887.0000 4 4 1/10/21

Bolt

Location	Loc Qty	Loc Code
FG	10	
122141	10	
ST513	877	
m125709	877	

NAS1149C0332R Purchased No 110 Each 10,182.000 38 38 1/10/21

WASHER

Location	Loc Qty	Loc Code
GA	1197	
125654	1197	
st510	8985	
m126319	1109	
m127306	2500	
m127410	3000	
m127831	2376	

D4095-041 Manufactured No 110 Each 7.0000 1 1 1/10/21

Wearplate Assembly

Location	Loc Qty	Loc Code
FP002	7	
109667	7	

D4095-043 Manufactured No 110 Each 0.0000 1 1 1/10/21

Wearplate Assembly

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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Required Date: 1/30/14

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Qty: 1.00

Required Qty: 1.00

D4095-045

Manufactured No

110 Each 7.0000

Wearplate Assembly

¹ 3115940 ¹ (12) *ll* 1/167/21

Location

Loc Qty

Loc Code

FP002

7

108288

1

109669

6

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